Sample Welding Procedure Specification (WPS) Form

Welding Procedure Specification (WPS) No. _____

Contractor _____

Authorized by _____ Revision No. _____

Supporting PQR Identification_____ Test Date _____

WELDING PROCESS: ☐ FCAW-S ☐ FCAW-G ☐ GMAW ☐ SMAW

WELD ☐ Groove ☐ Fillet

TYPE: ☐ Direct ☐ Indirect Butt ☐ T-Joint

JOINT Butt

TYPE:

Joint(s) Qualified (see Table 6.3) _____

Position_____ Groove Type_____

Root Opening _____ Root Face _____ Groove Angle _____

Backing: ☐ Yes ☐ No Backing Type _____

Backgouging: ☐ Yes ☐ No Backgouging Method _____

TECHNIQUE: ☐ Stringers ☐ Weave

ELECTRICAL CHARACTERISTICS

Current: ☐ AC ☐ DCEP ☐ DCEN

Transfer Mode (GMAW): ☐ Short-circuiting ☐ Globular ☐ Spray

BASE METAL

Material Specification_____ Grade_____

Welded to: Material Specification_____ Grade _____

Maximum Carbon Equivalent ____ Bar size _____ Plate Thickness _____

Coated Bar: ☐ Yes ☐ No Type of Coating _____

FILLER METAL

AWS Specification_____ AWS Classification _____

Describe filler metal (if not covered by AWS specifications) _____

SHIELDING

Gas: ☐ Single ☐ Mixture Composition _____ Flow rate _____

PREHEAT/INTERPASS

Preheat/Interpass Temperature (Min) _____ Interpass Temperature (Max) _____

WELDING PARAMETERS

Pass Number(s)	Electrode Diameter	Current				Travel Speed ipm [mm/min.]	Joint Detail
		Type	Amperage Range	Volts Range	Electrical Stickout		

Manufacturer or Contractor _____

Authorized by _____ Date _____

Form A-2